

Date: Tuesday, 7/10/2007 1:05:53 PM
 User: Kim Johnston

Process Sheet

| | | | | |
|-----------------------|--|--|------------------|-------------|
| Customer | CU-DAR001 Dart Helicopters Services | | Drawing Name | WEARSHOE |
| Job Number | 33456 | | | |
| Estimate Number | 12788 | | | |
| P.O. Number | N/A | | Part Number | D356413 |
| This Issue | 7/10/2007 S.O. No. N/A | | Drawing Number | D3564 REV C |
| Prsht Rev. | NC | | Project Number | N/A |
| First Issue | N/A | | Drawing Revision | C |
| Previous Run | 32247 | | Material | N/A |
| Written By | | | Due Date | 7/17/2007 |
| Checked & Approved By | | | Qty: | 20 |
| Comment | Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM | | Um: | Each |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---|
| 1.0 | M304S16GA | 304/316 .063 Sheet <i>HR 07-07-10</i> |
| | | Comment: Qty.: 0.1785 sf(s)/Unit Total : 3.5700 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: M161823 |
| 2.0 | WATER JET | FLOW WATER JET <i>HR 07-07-10</i> |
| | | Comment: FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: C Prog Rev: C |
| | | 2-Deburr if necessary |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE <i>HR 07-07-10</i> |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE |
| 4.0 | QC8 | SECOND CHECK <i>CS 07/07/11</i> |
| | | Comment: SECOND CHECK |
| 5.0 | BRAKE NC | NC BRAKE <i>SAD 07/07/15 (14)</i> |
| | | Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT9 and DT 8155 |
| | | <i>SAD 07/07/17 (20)</i> |

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 7/10/2007 1:05:53 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 33456

Part Number: D356413

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

5 07/07/20

7.0 POWDER COATING POWDER COATING



M104846



QX

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-l 07/07/20

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



m-l 07/07/21



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1 PACKAGING RESOURCE #1



QX

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

m-l 07/07/23

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(Q)

Comment: FINAL INSPECTION/W/O RELEASE

5 07/07/23

Job Completion



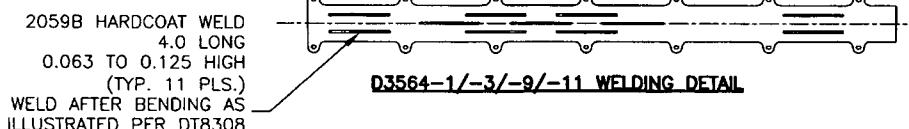
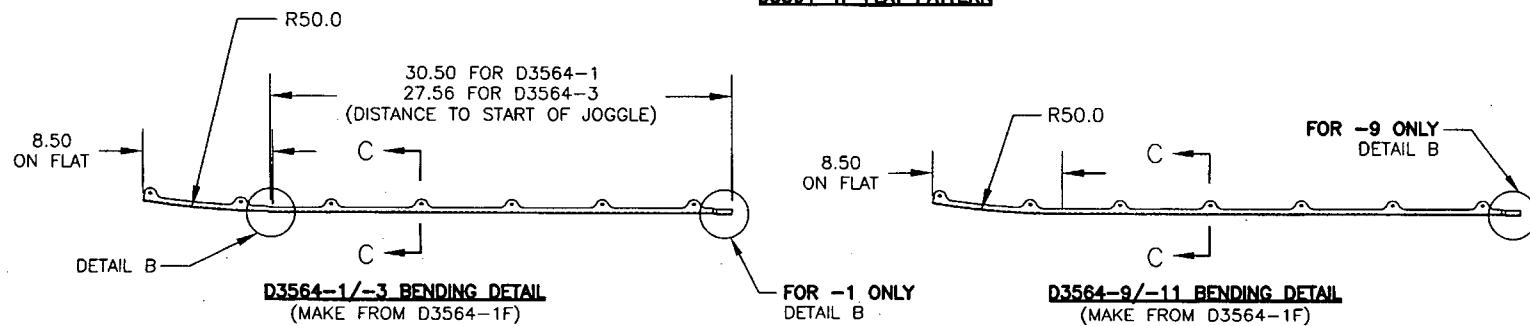
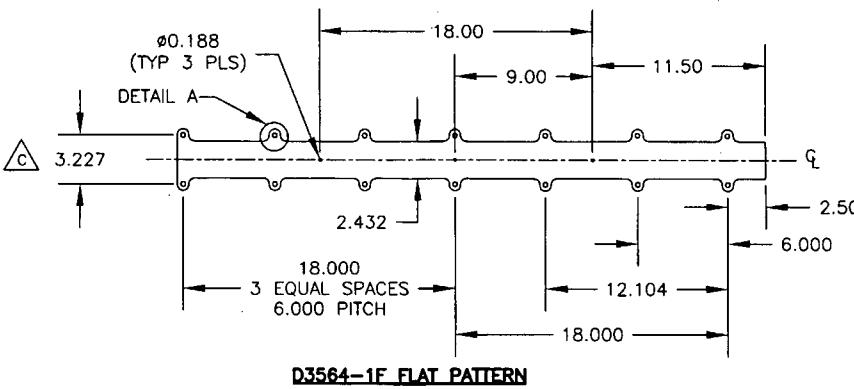
U 07-07-23

| W/I/O: | | WORK ORDER CHANGES | | | | | |
|--------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

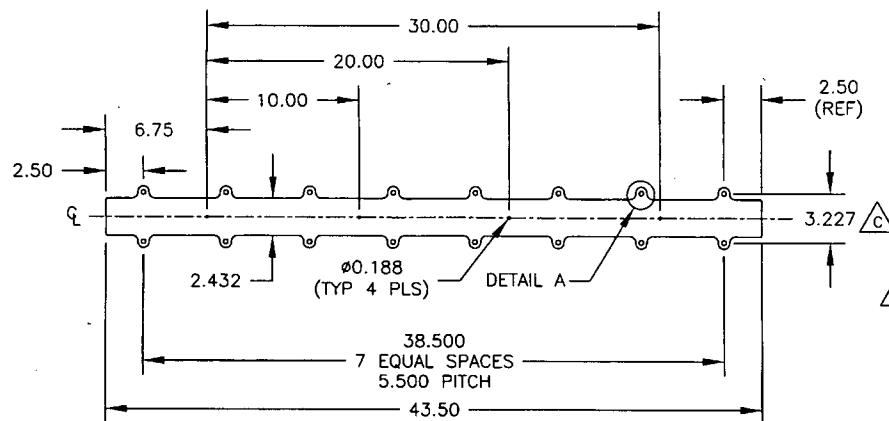
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

NO
33456
UNCONTROLLED COPY
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WORK ORDER
ENGINEERING
RETURN TO
SHOP COPY

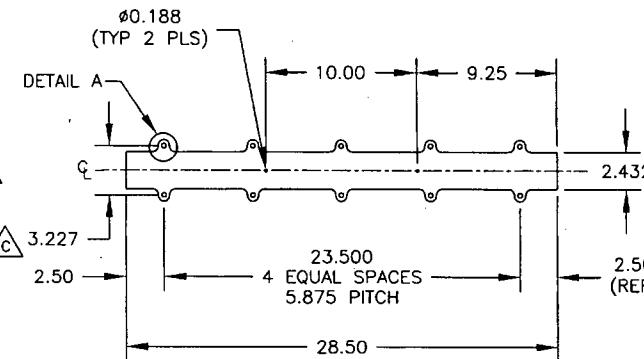
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|--------|----------|-----------|--|
| DESIGN | DRAWN BY | DART | |
| C | P4 | P4 | DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA |
| B | 07.03.20 | APPROVED | REV. C |
| A | 06.12.18 | NEW ISSUE | SHEET 1 OF 2 |
| DATE | 07.04.17 | TITLE | WEARSHOE |
| | | SCALE | 1:8 |

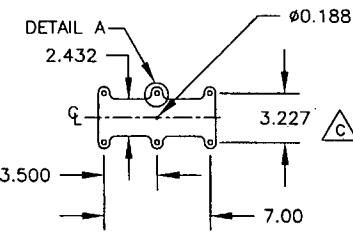
RELEASED
07.06.28



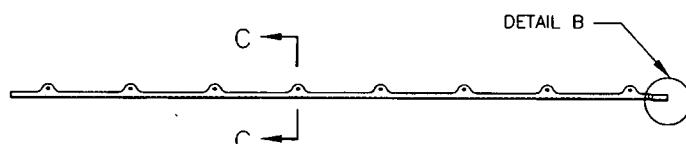
D3564-5F FLAT PATTERN



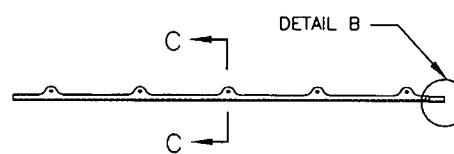
D3564-7F FLAT PATTERN



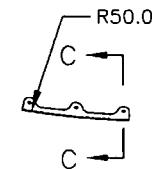
D3564-13F FLAT PATTERN



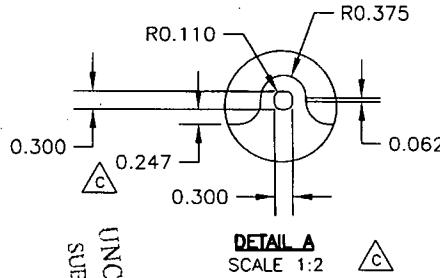
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



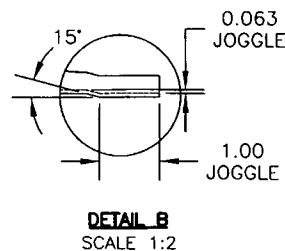
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



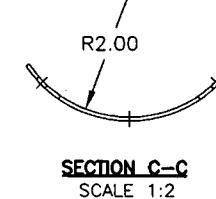
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



NO. 33426
WORK ORDER
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DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

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|----------|----------|-------|---|
| CHECKED | APPROVED | | REV. C |
| | | D3564 | SHEET 2 OF 2 |
| DATE | TITLE | | SCALE |
| 07.04.17 | WEARSHOE | | 1:8 |

RELEASED
07.06.2017

| | | |
|--------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 33456 |
| Description: | Part Number: | 03564-13 |
| Inspection Dwg: | Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | HB | Audited by: | SN | Prototype Approval: | N/A |
| Date: | 01-07-10 | Date: | 07/07/11 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/RF | |